



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBD29905-11
Job Sheet 195944



Part No: RBD29905-11

Job Qty: 2 pcs

Part Name: Short Center Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/3/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBD29905 Rev G IPP Rev A 17.11.15 New issue DP Verify DD/IPP Rev B 18.03.08 New DWG update.
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	SL-154 - 1	2 pcs	7/12/19	7/12/19	0.00	0.50	SL-154 - 1	11/07/07
120	QC 2	2 pcs	7/12/19	7/12/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	19/07/07
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Container No: S196303



Part: RBD29905 - 11

Job No: 195944

Serial No/Batch: S196303

Revision: G

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/07/19

Plex 6/3/19 10:45 AM Dart.lajeunesse.marie

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	2 pcs	7/12/19	0.00 0.00	QC 8 - 12	m 19/07/08
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	QC 5	2 pcs	7/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
150	Outsource - 12 - Black Oxide	2 pcs	7/12/19		GRO002-VC	6 Kd 2019-07-10
160	Packaging 2-1 - Receive - B4B	2 pcs	7/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	

					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
170 QC 6	2 pcs	7/12/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS 81
					QC 6 - 40	9-89
180 Packaging 3-1 - Stock - B4B	2 pcs	7/12/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	2 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	2-89 JUL 23 2019

Part Op 110 - SL-154 (MORI SL-154 LATHE) 1-Machine as per DWG. FB665 FOLIO REV: AA DWG REV:

Descriptions: G 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO 43957 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
 160 - (Receive & Inspect for Damage & Mat'l Certs)
 170 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1018R0.500	1018-1025 round bar .500	.2200 ft (.11 ea)	110-SL-154 - 1	<u>5 145018</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	M1018R0.500	0	1	0

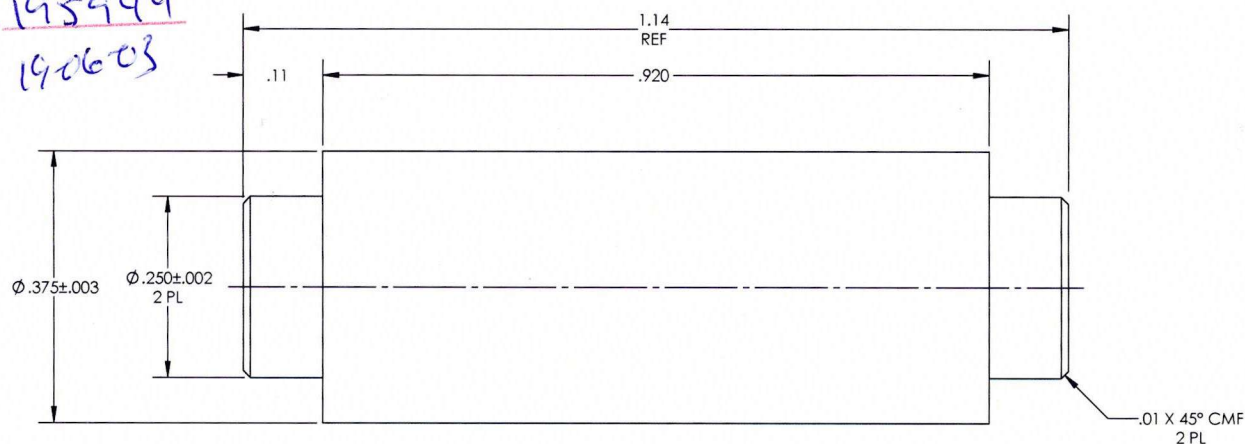
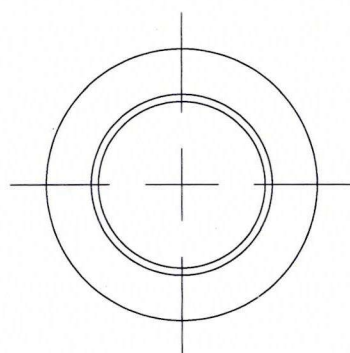
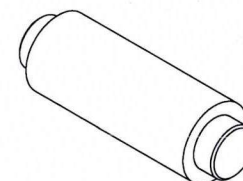
Part Specifications
Specifications could not be found.

GA
141

Plex 6/3/19 10:45 AM Dart.lajeunesse.marie

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	DIMENSION .925 CHANGED FOR .920, DIMENSION .250 +0/- .002 CHANGED FOR .250 +0/- .002, DIMENSION .375 +0/- .005 CHANGED FOR .375 +/- .003, CMF ADDED, TEMPLATE UPDATED	17-791	18.1.19	VM	ML

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195944 *ML*
190603



RBD29905-11 SHORT CENTER PIN

- NOTES:
1) MATERIAL: AISI 1018/1020 CR
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE
4) SPEC: MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: N/A

DART AEROSPACE		Hawkesbury Ontario Canada	
TITLE SHORT CENTER PIN			
PART NO. RBD29905-11		REV G	
TOOL NO. RBD29905		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
INITIALS AND DATE		TOLERANCES:	
DESIGNED BY: VM 1/19/2018		XXX ± .005	FRACTIONS ± 1/8
DRAWN BY: ML 02/05/2018		XX ± .01	ANGLES ± .5°
CHECKED BY: ML 02/05/2018		X ± .1	SURFACE ROUGHNESS
MFG REVIEW BY: RQ 02/05/2018		SCALE: NTS SHEET 9 OF 11	
APPROVED BY: <i>ML</i> ML 02/05/2018		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043957



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043957
PO Date: 7/9/19
Due Date: 7/17/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	R197342	RBE350A94- 3700-C-01	Tube -Issue P/O; -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; A513 -Certificate of Conformity is required	Firmed	-	7/17/19	7 pcs	0 pcs	7 pcs	\$0.01/pcs	\$0.07
2	195959	RB877206- 5-1	Shaft Outsource12 (Outside Processing - Black Oxide) 1- Issue P/O to Groupe Altech; PO 2- Black oxide finish, MIL-C-13924C Class 1 3- Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$2.25/pcs	\$18.00



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PURCHASE ORDER

POHB043957



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	195944	RBD29905-11	Short Center Pin (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$1.75/pcs	\$14.00
4	195945	RBD29905-13	Long Center Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	8 pcs	0 pcs	8 pcs	\$1.90/pcs	\$15.20
5	196129	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/17/19	32 pcs	0 pcs	32 pcs	\$2.50/pcs	\$80.00
6	196184	RBIR7028-1	Receiver (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$3.40/pcs	\$30.60



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	196185	RBIR7028-3	Remover / Installer (Outside Processing - Black Oxide)-Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$2.35/pcs	\$21.15
8	196186	RBIR7028-5	Alignment Seat (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL- C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF- 16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/17/19	9 pcs	0 pcs	9 pcs	\$2.80/pcs	\$25.20
Grand Total:											\$204.22



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB043957



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 11:00 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020660-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

020660 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.
19-Jul-2019	Jigar Patel		POHB043957 ✓

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities					À venir/ Back Order
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/		
✓ 1	RBE350A94-3700-C-01 REWORK Rev.	RBE350A94-3700-C-01 REWORK SAND BLAST ALL OVER BLACK OXIDE MIL-C-13924C, CLASS 1 APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	BLACK-OXIDE N/C	7	7 ✓	0	0		0
✓ 2	RB877206-5-1 Rev.	RB877206-5-1 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8 ✓	0	0		0
✓ 3	RBD29905-11 Rev.	RBD29905-11 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C, CLASS 1 ***	BLACK-OXIDE CH	8	8 ✓	0	0		0
✓ 4	RBD29905-13 Rev.	RBD29905-13 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C, CLASS 1 ***	BLACK-OXIDE CH	8	8 ✓	0	0		0
✓ 5	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	32	32 ✓	0	0		0
✓ 6	RBIR7028-1 Rev.	RBIR7028-1 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9 ✓	0	0		0
✓ 7	RBIR7028-3 Rev.	RBIR7028-3 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9 ✓	0	0		0

RECEIVED
 JUL 19 2019
 DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance

(020660-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
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 www.groupaltech.com

Bon de Livraison / Packing Slip

020660 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
19-Jul-2019		Jigar Patel			POHB043957			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
8	RBIR7028-5 Rev.	RBIR7028-5 SAND BLAST ALL OVER OXIDE-BLK & OIL [OXIDE BLACK AND OIL] APPLY THIN LAYER OF OIL /CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	9	9	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jg 344

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.